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D139-799-039
Job Sheet 180438



Part No: D139-799-039

Job Qty: 1 ea

Part Name: AW139 Easy Access Engine Oil Drain



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/6/18

Job Tracking No:

Created By: Linda Lacelle

Due Date: 7/13/18

Type: SOLD

Description:

Note: IIN-D139-799 REV.O IPP REV:A 16.10.07 NEW ISSUE DD VERF:JFS IPP REV:B 17.09.18 AS PER IIN
REV.N DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	7/13/18	7/13/18	0.00	0.00	Start Up Stores/Pkg-1	6	JUL 06 2018
110	Packaging	1 pcs	7/13/18	7/13/18	0.00	0.00	Packaging1-1	6	JUL 06 2018
120	QC	1 pcs	7/13/18	7/13/18	0.00	0.00	QC4	6	JUL 06 2018
125	DC	1 pcs	7/13/18	7/13/18	0.00	0.00	DC	6	JUL 06 2018
130	Packaging	1 pcs	7/13/18	7/13/18	0.00	0.00	Packaging3-1	6	JUL 06 2018
140	QC21-FG	1 Ea	7/13/18	7/13/18	0.00	0.00	QC21	6	JUL 06 2018

Part Op 125 - Photocopy bluefile & type labels per PPP D139-799-039 CHG003
Descriptions: 130 - Identify and pack for shipping as per PPP D139-799-039

F9019

JUL 09 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN3C3A	Bolt	10 Ea (10 ea)	90-Start up Operation	5019590
AS3208-06	Packing	2 Ea (2 ea)	90-Start up Operation	5001689
D5370-1	Fitting	2 Ea (2 ea)	90-Start up Operation	5050554
D5373-11	Oil Drain Line	1 Ea (1 ea)	90-Start up Operation	5001757
D5373-3	Oil Drain Line	1 Ea (1 ea)	90-Start up Operation	5001241
D5373-7	Oil Drain Line	1 Ea (1 ea)	90-Start up Operation	5001237
D5373-9	Oil Drain Line	1 Ea (1 ea)	90-Start up Operation	5001716
D5521-041	Oil Drain Hose Assembly	4 Ea (4 ea)	90-Start up Operation	5080362
D5522-041	Oil Drain Valve Assembly	1 Ea (1 ea)	90-Start up Operation	5079340
D5522-042	Oil Drain Valve Assembly	1 Ea (1 ea)	90-Start up Operation	5079342
MS21043-3	Nut	10 Ea (10 ea)	90-Start up Operation	5062620
MS21919-WDG7	Clamp	2 Ea (2 ea)	90-Start up Operation	50010323
MS21919WDG10	Clamp	6 Ea (6 ea)	90-Start up Operation	5004854
MS27039C1-12	Screw	2 Ea (2 ea)	90-Start up Operation	5046909
MS27039C1-14	Screw	2 Ea (2 ea)	90-Start up Operation	5046909
MS9592-005	Bracket	2 pcs (2 ea)	90-Start up Operation	5046909
NAS1149C0332R	Washer	24 Ea (24 ea)	90-Start up Operation	5046909
SW-6-TEF	Teflon Spiral Wrap	3 ft (3 ea)	90-Start up Operation	5046909

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR N _____ Date : _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																		
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																		
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																		
Large Fab ☐	Composite ☐	Supplier ☐																			
		QTY Effective : _____		MRB (QS1042) Approval																	
Deviation _____ Date: 07/06/16		Disposition _____		Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____																	

FAULT CATEGORY				
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐
		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : _____	

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN3C3A	10	328	0
	AS3208-06	2	158	0
	D5370-1	2	26	0
	D5373-11	1	9	0
	D5373-3	1	13	0
	D5373-7	1	9	0
	D5373-9	1	9	0
	D5521-041	4	4	0
	D5522-041	1	7	0
	D5522-042	1	5	0
	MS21043-3	10	1,065	0
	MS21919-WDG7	2	18	0
	MS21919WDG10	6	31	0
	MS27039C1-12	2	44	0
	MS27039C1-14	2	47	0
	MS9592-005	2	38	0
	NAS1149C0332R	24	4,755	0
	SW-6-TEF	3	82	0
Part Specifications				
Specifications could not be found.				

Plex 7/6/18 8:34 AM dart.lacelle.linda

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		

Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____							
Misidentified	☐	Past Due	☐								

Change Record

PAGE 1 OF 1

Part Number: D139-799-039

Description: ENGINE OIL DRAIN INSTALLATION

[illegible]

Qty -035	Qty -036	Qty -037	Qty -038	Part Number	Description
X				D139-799-035	HEAVY DUTY REPLACEMENT CABIN STEP KIT LH
	X			D139-799-036	HEAVY DUTY REPLACEMENT CABIN STEP KIT RH
		X		D139-799-037	LIGHT WEIGHT REPLACEMENT CABIN STEP KIT LH
			X	D139-799-038	LIGHT WEIGHT REPLACEMENT CABIN STEP KIT RH
1				D5235-041	LH STEP ASSEMBLY
	1			D5235-042	RH STEP ASSEMBLY
		1		D5235-043	LH STEP ASSEMBLY
			1	D5235-044	RH STEP ASSEMBLY
1	1	1	1	*D5271-1	FORWARD AIRCRAFT FITTING
1		1		*D5271-3	LH AFT FITTING
	1		1	*D5271-4	RH AFT FITTING
1	1	1	1	*D5272-1	FORWARD TUBE
1	1	1	1	*D5272-3	AFT TUBE
2	2			*D5273-041	END FITTING ASSEMBLY
		2	2	*D5273-043	END FITTING ASSEMBLY
1	1			*D5274-1	STEP EXTRUSION
		1	1	*D5274-3	STEP EXTRUSION
14	14	14	14	*D5291-041	RADIUS BLOCK ASSEMBLY
12	12	10	10	*MS24694-S50	SCREW
14	14	14	14	*MS24694-S98	SCREW
28	28	28	28	*MS20426AD4-6	RIVET

*Part of D5235-041/-042/-043/-044 assembly, above.

Qty -039	Part Number	Description
X	D139-799-039	ENGINE OIL DRAIN KIT
2	D5370-1	FITTING
1	D5373-3	OIL DRAIN LINE
1	D5373-7	OIL DRAIN LINE
1	D5373-9	OIL DRAIN LINE
1	D5373-11	OIL DRAIN LINE
4	D5521-041	OIL DRAIN HOSE ASSY
1	D5522-041	OIL DRAIN VALVE ASSY
1	D5522-042	OIL DRAIN VALVE ASSY
10	AN3C3A	BOLT
2	AS3208-06	PACKING
2	MS9592-005	BRACKET
10	MS21043-3	NUT
2	MS21919WDG7	CLAMP
6	MS21919WDG10	CLAMP
2	MS27039C1-12	SCREW
2	MS27039C1-14	SCREW
24	NAS1149C0332R	WASHER
3 ft	SW-6-TEF	TEFLON SPIRAL WRAP